

shp March 20 Blue

Work Order ID 79655

79655

Page 1

Item ID: D206-642-341

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/02/01 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2650

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79655***79655***

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Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 31/01/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.								
	A/RAluminum Rod <u>M119785</u> <u>BE 12/02/14</u>								
	4-Grind weld flush to cap on top surface only. <u>BE 12/02/14</u>								
	5-Cut aft end to length as per dwg D2650								
	6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"								
	7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".								
	8-Open Aft Cap Hole using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650								
	11-Deburr and Blow out all chips from inside the tube								

1 Ø CF 12.2.14

1 Ø CF 12.2.15

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-2-16	110	while removing wear inner indipeng ridge employee dis-rod lug and removed 1.00" instead of 0.75"	UP 12.02.16 Q3/042	Acceptable	DD/CF 12-2-17		UP 12.02.16 Q3/042	
		RC; New, part time employee w/ lack of experience.	UP 12.02.16		DD/CF 12-2-17		UP 12.02.16	

NOTE: Date & initial all entries

Work Order ID 79655***79655***

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Item ID: D206-642-341

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	QC5- Inspect part completeness to step on W/O	0.00							
115									
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									
125	QC3- Inspect Part Finish	0.00							
125	QC7								
QC	Memo	0.00							
Quality Control									

PTO →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/02/17	125	SHOULD BE QC 7	BE	12/02/17			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 20/03/2012 Req'd Qty: 1.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.
cure time before cutting

Start Date: 12-02-17 Time: 1h30

Finish Date: 12-02-21 Time: 7:00

A/RSikaflex-291 M119999

Sikaflex expiry date: 2012-08-13

(i)

SAD 12-02-17

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SAD 12-02-17

1 0 BE 12/02/17

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Start Date: 31/01/2012 **Start Qty:** 1.00 ***1***

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Required Date: 20/03/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

150

Skidtubes

Memo

0.00

Skidtubes

Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/Aluminum Rod *m/12/01/64* *BF 12/0*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

4- Install nut plate as per dwg

170

QC10- Inspect visual per QSI004- ground welds	0.00
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170

QC

Memo

0.00

Quality Control

SL 12.02.23 - 1 ~~0~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								
205		0.00							
205									
SprayPaint	Memo	0.00							
Spray Painting	PRIME B <u>118319</u> DELFLEET BLUE B <u>118395</u> CLEAR DELFLEET B <u>118093</u>								

m 12 *or* 2-3 *(1)*

1 *(SP)* Feb. 24/2012

AB 12-3-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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79655

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N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

215

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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February-01-12 11:24:11 AM

Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00

220

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.
A/RSikaflex-291 M119443
Sikaflex expiry date: 12/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive
A/RSikaflex-291 M119443
Sikaflex expiry date: 12/10

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4
Batch: M 120125

1X0 M/L 12/03/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 79655***79655***

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February-01-12 11:24:11 AM

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Item Name: Replacement Skidtube

Start Date: 31/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

1 BR 123-19

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

1 BR 123-19

250

Packaging

0.00

250

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-341

Location:

PPP Rev:

JRP 79634

10/2/3/20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 31/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.00

Quality Control

MLJ 12/03/20

MLJ 12/03/20
④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 79655

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Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416	NAS1149D0463J	Purchased	No				Each	0.0000		1			
AN960JD416													
Washer													
CCR264SS3-3		Purchased	No				Each	867.0000		2			
CCR264SS3-3													
Cherry Rivet													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST331			867						
				113973			2						
				117849			135						
				119017			730						
CR3212-4-03		Purchased	No				Each	1,632.000		2			
CR3212-4-03													
Cherry Rivet													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				FP002			642						
				114859			642						
				ST331			990						
				110139			2						
				119017			988						

M118384

**

M-1 12/03/16

**

SAD 12-02-21

**

SAD 12-02-21

2

W/O:		WORK ORDER CHANGES					
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D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2620 Manufactured No

Each 58.0000 1

D2620

Skidtube, 206 Skidtube

B79545

**

① CF 12-2-16

Location Loc Qty Loc Code

LG	58	
71617	2	
76820	6	
77996	10	
77999	10	
78000	10	
79542	10	
79543	10	

D2647 Manufactured No

Each 120.0000 1

D2647

Cap

**

BE 12/02/14

Location Loc Qty Loc Code

LG002	120	
73826	12	
75482	108	

W/O:		WORK ORDER CHANGES					
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D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

Each

731.0000

19

D2649

Cross Bolt Spacer

**

BE 12/02/21

Location

Loc Qty

Loc Code

LG

415

77574

15

78019

400

19

LG001

316

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

197

D2654-5

Manufactured No

Each

4.0000

1

D2654-5

Web

**

SAD 12-02-17

Location

Loc Qty

Loc Code

LG

4

78832

4

BZ0057

1

W/O:		WORK ORDER CHANGES					
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D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

Each

101.0000

1

D2680-041

Nut Plate

**

SAD 12-02-21

Location

Loc Qty

Loc Code

ST013

5

75479

5

ST019

96

76790

96

(i)

MS27039C1-08

Purchased

No

Each

1,542.000

56

MS27039C1-08

SCREW

**

m 12/03/16

Location

Loc Qty

Loc Code

FP002

1

116022

1

ST292

1000

120308

1000

ST293

541

116373

3

118077

14

118159 ✓

412

119309 ✓

112

20
36
54

4
ALS-1032-130

Purchased

No

220

Each

2,033.000

54

ALS4-1032-130

Insert

**

m 12/03/16

Location

Loc Qty

Loc Code

ST280

944

119084

944

ST281

1089

119632

89

120410

1000

120181

54

February-01-12 11:24:16 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

February-01-12 11:24:16 AM

Work Order ID: 79655

79655

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

220 Each 0.0000 54 54

*AN960C10I *

washer

120648 **

54x m/l 12/03/16

AN960JD10L NAS1149D0332J Purchased No

220 Each 0.0000 2 2

*AN960.ID10I *

Washer

12644 **

2x m/l 12/03/16

D2646 Manufactured No

220 Each 4.0000 1 1

D2646

Aft Cap

**

Location

Loc Qty

Loc Code

FP002

74

62678

5

68280

5

70945

1

71070

2

73294

1

73825

60

78018

m/l 12/03/16

*

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-01-12 11:24:16 AM

Page 6

Work Order ID: 79655

79655

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

220

Each

705.0000

14

14

D2651-1

Plug

79234

**

14x M-L 12/03/16

Location

Loc Qty

Loc Code

FP001

699

57869

1

66445

10

69018

2

70827

2

70839

8

71037

11

72864

25

73827

23

78584

317

FP-A

6

77559

22

78124

284

D2651-3

Manufactured No

220

Each

2,383.000

14

14

D2651-3

O-Ring

**

M-L 12/03/16

Location

Loc Qty

Loc Code

FP001

383

61962

12

73828

371

FP-A

2000

78126 ✓

2000

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

February-01-12 11:24:16 AM

Work Order ID: 79655

79655

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-11

Manufactured No

220 Each

14.0000

1 1

D3535-11

Wearshoe

**

m-l 12/03/16

Location

Loc Qty

Loc Code

FP001

14

70879

1

71284 ✓

13

D3535-23

Manufactured No

220 Each

29.0000

1 1

D3535-23

Wearshoe

**

m-l 12/03/16

Location

Loc Qty

Loc Code

FP001

29

73314 ✓

18

74508

11

D3535-35

Manufactured No

220 Each

14.0000

1 1

D3535-35

Wearshoe

**

80332

1x m-l 12/03/16

Location

Loc Qty

Loc Code

FP001

14

67598

1

70815

1

74509

12

D3536-11

Manufactured No

220 Each

10.0000

1 1

D3536-11

Gasket

**

80006

1x m-l 12/03/16

Location

Loc Qty

Loc Code

FP002

10

46649

1

46715

4

65574

1

71283

4

February-01-12 11:24:16 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-01-12 11:24:16 AM

Page 8

Work Order ID: 79655

79655

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-23

Manufactured No

220 Each

28.0000

1

1

D3536-23

Gasket

**

M/L 12/03/16

Location

Loc Qty

Loc Code

FP002

28

43406

1

73312 ✓

15

74510

12

IX

D3536-35

Manufactured No

220 Each

25.0000

1

1

D3536-35

Gasket

**

M/L 12/03/16

Location

Loc Qty

Loc Code

FP002

25

73313 ✓

7

74511 ✓

18

IX

D3537-1

Manufactured No

220 Each

33.0000

6

6

D3537-1

Wearpad

**

79834

6X M/L 12/03/16

Location

Loc Qty

Loc Code

FP002

33

69817

5

77560

28

IX

D3537-3

Manufactured No

220 Each

30.0000

1

1

D3537-3

Wearpad

**

M/L 12/03/16

Location

Loc Qty

Loc Code

FP002

30

74500 ✓

25

76986

5

IX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-01-12 11:24:16 AM

Page 9

Work Order ID: 79655

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

79655

D206-642-341

Start Date: 31/01/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

220

Each

255.0000

1

1

MS27039-4-06

Screw

**

M-L 12/03/16

Location

Loc Qty

Loc Code

ST292

255

119075 ✓

255

IX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

UNCLASSIFIED
SUBJECT TO
REVIEW
NO. 79.655 M.L.J
12/02/01

RELEASED
08-07-23/17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	B	D2650	SHEET 1 OF 6
APPROVED	AP	TITLE	SCALE
DE APPR.	H	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

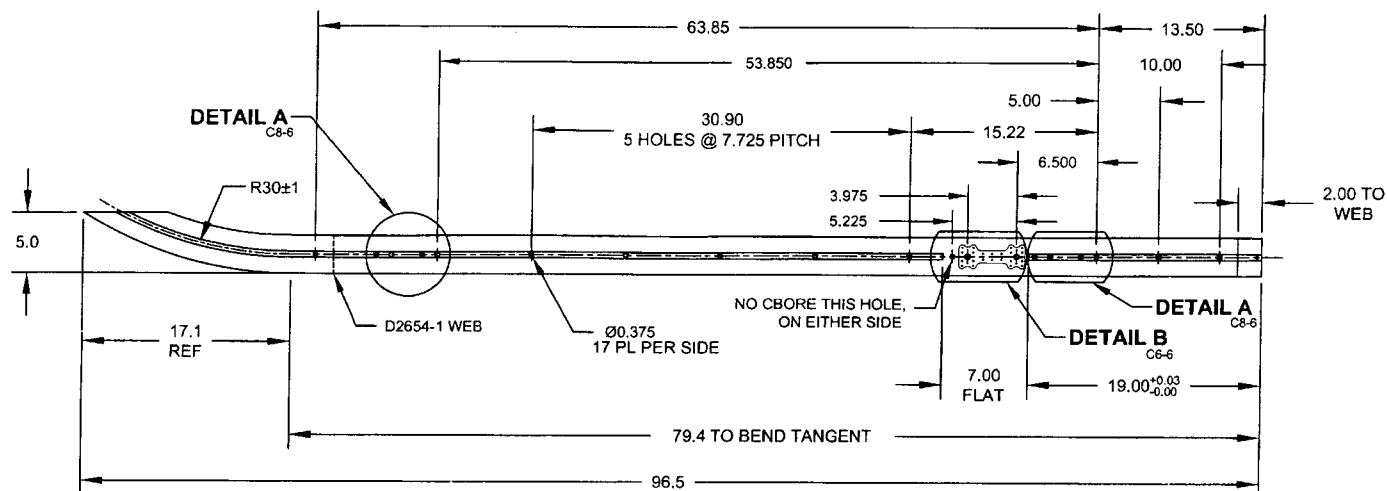
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

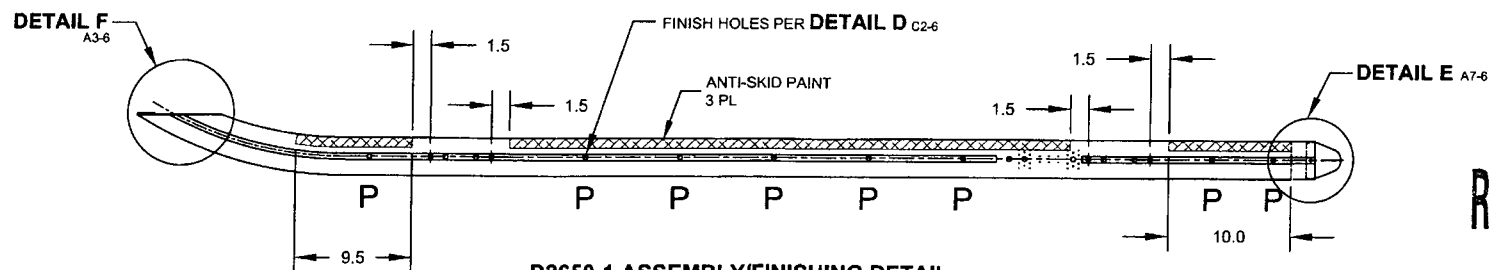
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79655



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
68 09 22 111

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a shaft detail, likely a propeller shaft, showing dimensions and callouts. The drawing includes a side view of the shaft with a curved section on the left and a flange on the right. Key dimensions and callouts include:

- Dimensions:**
 - 68.50 (Total length)
 - 63.50 (Length to first hole)
 - 53.50 (Length to flange)
 - 15.50 (Flange width)
 - 10.00 (Distance from end to flange)
 - 5.00 (Distance from end to first hole)
 - 30.90 (Distance between holes)
 - 5 HOLES @ 7.725 PITCH
 - 14.87 (Distance from last hole to flange)
 - 6.500 (Flange thickness)
 - 3.975 (Distance from end to first hole)
 - 5.225 (Distance from end to first hole)
 - 7.00 FLAT (Flange thickness)
 - 21.00^{+0.03}_{-0.00} (Distance from end to flange)
 - 2.00 TO WEB (Distance from end to web)
 - 17.1 REF (Reference dimension)
 - 87.0 TO BEND TANGENT (Distance to bend tangent)
 - 104.1 (Total length)
- Callouts:**
 - DETAIL A C8-6** (Pointing to the curved section)
 - DETAIL B C8-6** (Pointing to the flange)
 - R30±1** (Radius of the curved section)
 - D2654-3 WEB** (Web of the flange)
 - DO NOT CBORE THIS HOLE, ON EITHER SIDE** (Instruction for the central hole)
 - Ø0.375 18 PL PER SIDE** (Hole specification)

Technical drawing of a handrail assembly. The drawing includes a side view and an end view. The side view shows a handrail with a curved end on the left and a straight section on the right. Dimensions include 15.5 for the curved section, 12.0 for the straight section, and 1.5 for the distance between mounting holes. Callouts include "DETAIL F A3-6" for the curved end, "FINISH HOLES PER DETAIL D C2-6" for the mounting holes, and "ANTI-SKID PAINT 3 PL" for the handrail surface. The end view shows a circular cross-section of the handrail with a diameter of 12.0. A partial view of another detail, "DETAIL E A7-6", is visible on the right.

RELEASE
05 07 22 1974

DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. OF
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

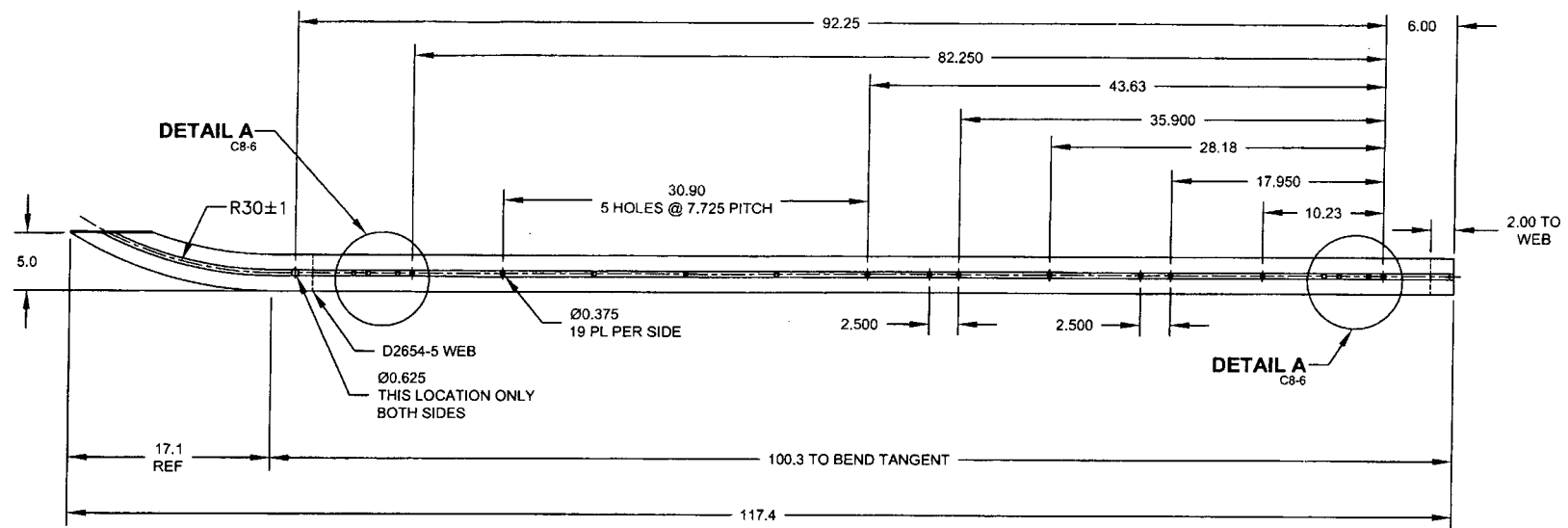
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

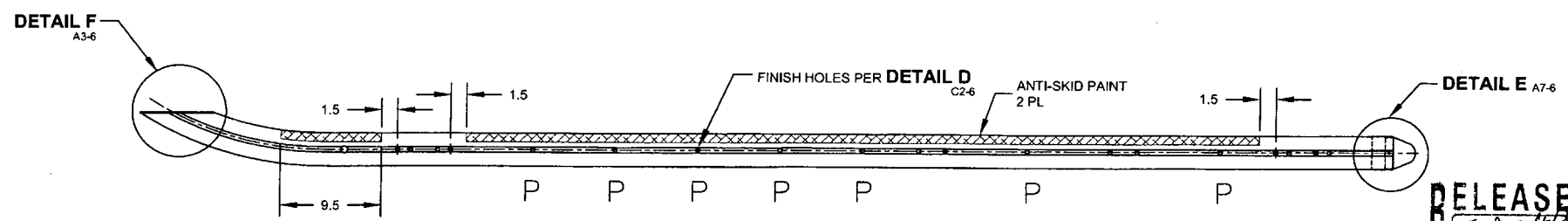
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79655



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

RELEASED
09-22-1979

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	[Signature]	D2650	SHEET 4 OF 6
APPROVED	[Signature]	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

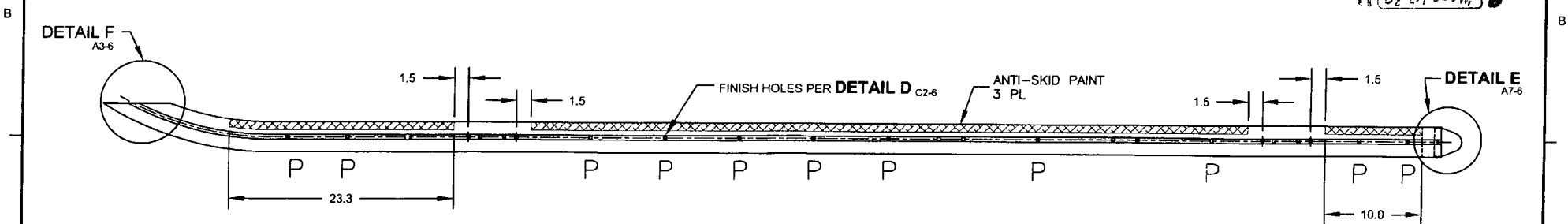
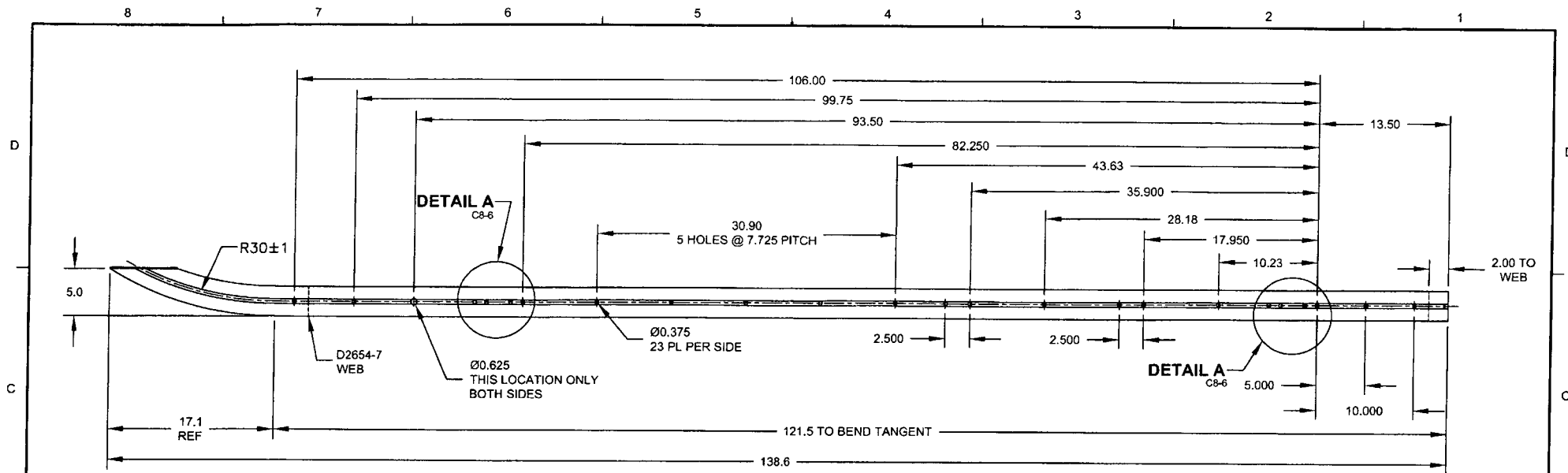
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79655



RELEASED
08 07 22

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

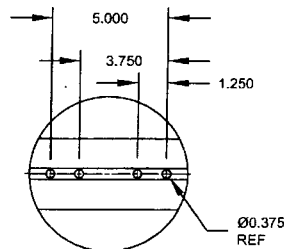
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

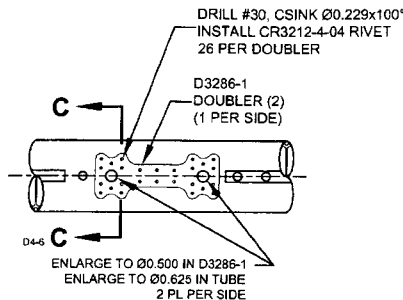
NOTE: Date & initial all entries

79655



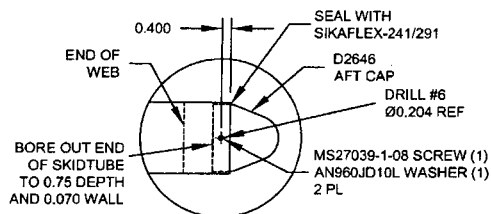
DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5



DETAIL B
SCALE 2X

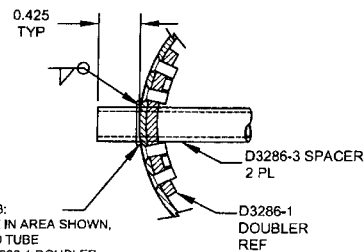
C3-2
C3-3



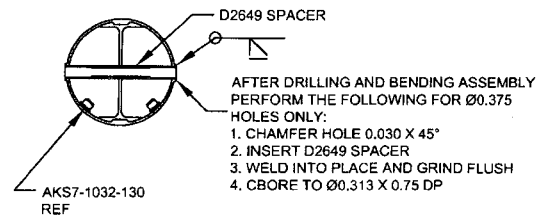
DETAIL E
SCALE 2X

B2-2
B2-3
B1-4
B1-5

SECTION C-C C7-6
SCALE NONE

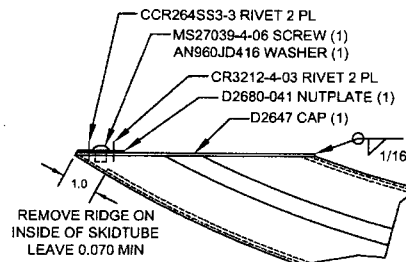
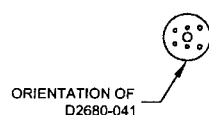


- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5



DETAIL F
SCALE NONE

B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-2019

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries